

REQ THURS 16/07 !

Work Order ID 50553

Jul 15, 2009 10:43:52 AM

Page 1

PROTOTYPE

Item ID: D3955-7

Accept

Revision ID: A-PROTO

Item Name: Plate

Start Date: 7/15/09

Start Qty: 1.00

Required Date: 7/16/09

Req'd Qty: 1.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan: W

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3955	A-PROTO

100
Waterjet
FLOW CNC Waterjet

Memo

1-Cut as per Dwg D3955
Dwg Rev: A-PROTO
Prog Rev: A-PROTO

2-Deburr if necessary

QC2- Inspect parts off machine FAI/FAIB

110
QC
Quality Control

Memo

0.00

0.00


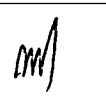

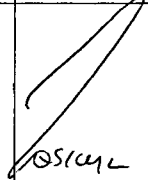
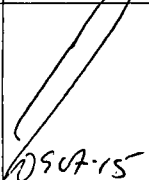
0.00

0.00

ml 09 07 15 (1)
24-07-09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3955-7 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR: <u>50553</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
0507-15	100 2 110	1st part came out too short i was then deburred too short again when the tab was removed. RC: WS - Human error.		Scrap & replace. Qty 1	 090715 ①			

NOTE: Date & initial all entries

Work Order ID 50553

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Page 2

Item ID: D3955-7

Accept



Setup Start



Revision ID: A-PROTO

Stop



Item Name: Plate

Start Date: 7/15/09

Start Qty: 1.00



Cust Item ID:

Required Date: 7/16/09

Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC8- Inspect parts - second check

0.00



01

1

09-07-15

QC

Quality Control

Memo

ENGINEERING
APPROVAL

0.00

130

Identify as per dwg & Stock Location:

0.00



Packaging

Memo

0.00

Packaging

Mike ENG LAB

140

QC21- Final Inspection - Work Order Release

0.00



QC

Quality Control

Memo

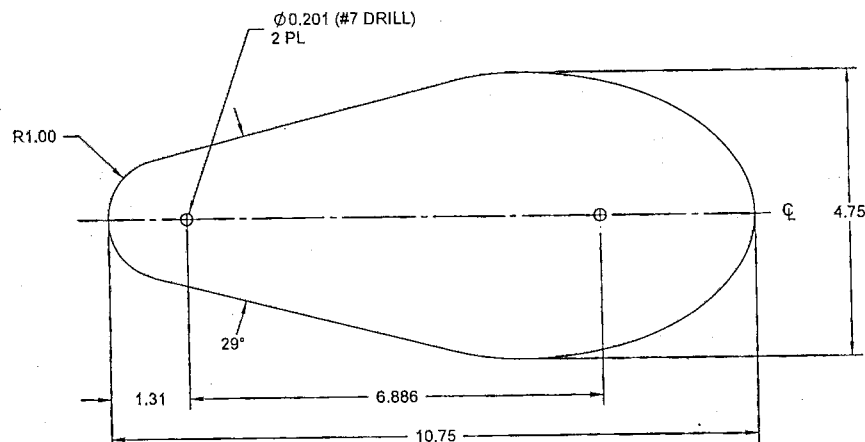
0.00

09/07/2809

RIDGOSA JIL

D39557

Status	Item ID	Rev	Name	Start Date	Quantity	Per	Comp Date	Sec	ap	Qua	mmend	N	C	L	OX	S	ortine	Off	se	n	Ty	1	Pa	Ord	to	ore	Ca	Last	Id	Da
	M304511GA		304/316 0.125 S...	7/08/09	0.3545	sf		100	5	0.0...						1	0	M...										7/0...	7/...	



D3955-X PLATE

General Table			
P/N	T (in)	T (GA)	WEIGHT (lbs)
D3955-5	0.060	16	0.04
D3955-7	0.120	11	1.28

PROTOTYPE
PLEASE RETURN ALL ISSUED
DATA TO ENGINEERING

09/06/30 JMW

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, T (GA) THICK (REF. DART SPEC. M304S_GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3955-X" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: SEE TABLE

DESIGN	DS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED		DRAWING NO. D3955	REV. A
MFG. APPR.		TITLE SKIDTUBE TUNING KIT	SHEET 3 OF 5
APPROVED		SCALE NTS	
DE APPR.		COPYRIGHT © 2009 BY DART AEROSPACE LTD	
DATE	09.06.23	THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR DISCLOSED TO ANY OTHER PERSON OR ENTITY WITHOUT THE WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

